

Work Order ID 104822

July-18-13 2:36:19 PM

104822

Page 1

Item ID: D3190-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chaffing Shield

Start Date: 7/18/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 1307-18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3190

Rev A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER DWG

DWG REV: A

PROG REV: A

12 0 Jm 3-08-14

105

QC2- Inspect parts off machine FAI/FAIB

0.00

105

QC

Memo

0.00

Quality Control

12 0 Jm 3-08-14

106

QC8- Inspect parts - second check

0.00

106

QC

Memo

0.00

Quality Control

SHP
13 8 14

12

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Page 2

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Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date: _____

Run Start *NR1*

QC:

Date: _____

SPC (Y/N):

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

107

107

SHEAR

0.00

Small Fab

Memo

0.00

Small Fab

Roll as per Dwg D3190

12x

3/08/19

110

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Smf
13-8-19

12

120

120

Identify as per dwg & Stock Location: 1702

0.00

Packaging

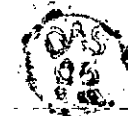
Memo

0.00

Packaging

AS4

12



13-08-21

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Page 3

Item ID: D3190-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Chaffing Shield

Start Date: 7/18/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

M65 13-08-21

13-08-21

Picklist Print

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Page 1
1

Work Order ID: 104822

104822

Parent Item: D3190-1

D3190-1

Parent Item Name: Chaffing Shield

Start Date: 7/18/13

Required Date: 8/01/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A03.05.26New issueKJ/RF

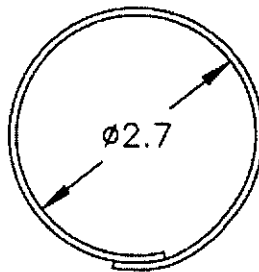
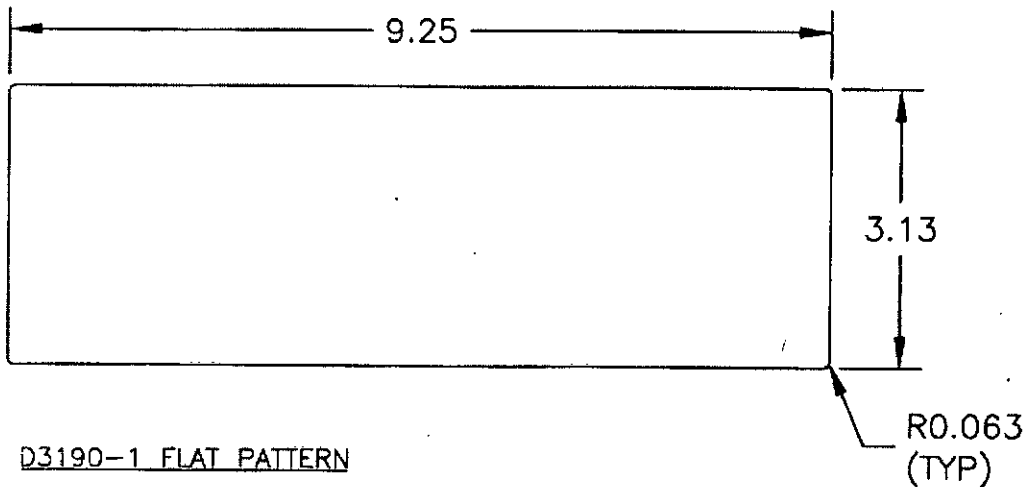
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S2SGA		Purchased	No			100	sf	0.0000	0.2153	226516			
M304S2HGA									**	3.0			Jm30814
304/316.020" Sheet													

125771

125771



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

17-07-16
MCS
N/104822
W/10
W/10
W/10
UNCONTIN
ENCL
P2
SH

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